












Date: Tuesday, 12/05/2009 1:29:44 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AVIONICS RISER CONSOLE
Job Number	: 47916		
Estimate Number	: 10259		
P.O. Number	:	Part Number	: D212722011
This Issue	: 12/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3363 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 46080	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	: <u>JUL 09 05 12</u>	Due Date	: 19/05/2009
Comment	: Est Rev:B 05.04.11 Now made at Dart KJ/JLM Est Rev:C 07-06-09 Holes now Transfer drilled JLM	Qty:	4 Um: Each
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D212-722-011 CHG002			
2.0	M6063T5A0750W063	Angle6063T5 .750 X.750 X.063w	
			
Comment: Qty.: 7.2450 f(s)/Unit Total : 28.9800 f(s) Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063) Batch: <u>17 111018 x 28.9699.25 / M 112040 x 100-75</u> FF 09-06-15 (4)			
3.0	M6063T5C75X75W125	6063 CHANNEL.750 X.750 X.125w	
			
Comment: Qty.: 0.8290 f(s)/Unit Total : 3.3160 f(s) Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)] Batch: <u>M107435</u> FF 09-06-15 (4)			
4.0	D33631	Console	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3363-1 Console (Bent) <u>46179</u> FF 09-06-15 (4)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall FF 09-06-05 (4)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 1:29:44 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 47916

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

FF 09-06-15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 09/06/23 (3X) (14) 09/06/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09/06/15

8.0

PR354

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total: 1.3332 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: M107913

FF 09-06-16

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 176.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 MS20426AD45-4 Rivet M14067

FF 09-06-16

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)



Pick:

Qty Part Number Description Batch

9 MS20426AD4-6 Rivet M105144

FF 09-06-16

Dart Aerospace Ltd

W/O: 47916		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/06/23	9	Change rivets MS 20426 AD 4-5 for MS 20426 AD 4-4 M <u>15541</u> for this application only	EB	09/06/23				

Part No: D212-722-011 PAR #: N/A Fault Category: Sm Fab NCR: (Yes) No DQA: 10 Date: 09-08-08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 09-08-19

NCR: 47916		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/16	11	Some countersink are too deep Qty 24 holes. (average 6 holes per part) R.C. Process: material flexed	<i>[Signature]</i>	Fill the affected holes with weld per AS1004. grind weld flush Re-Align on the part parasitic Transfer drill - C'sink per chg.	<i>[Signature]</i> 09-06-17 09/06/23	<i>[Signature]</i> 09/06/16 09/07/16	<i>[Signature]</i>	<i>[Signature]</i> 09/06/16
09/06/17	11.	1 x D3363-1 console is scrap. warped during a weld re-work	<i>[Signature]</i>	Scrap & destroy, no-replace Qty 1	<i>[Signature]</i> 09-06-17	<i>[Signature]</i> 09/07/16	<i>[Signature]</i>	<i>[Signature]</i> 09/06-17

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 1:29:44 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 47916

Part Number: D212722011

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail
Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.

2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363
Identify as D3363-041

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

14.0 PFSC3538A Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 PFSC35-38A Dzus Fastener

M110836 18X

M111779 2X

1 d3363-041 Console Ass

47916

09/17/16 (3)

15.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

17.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/07/16
3x SP
09/07/16
09/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

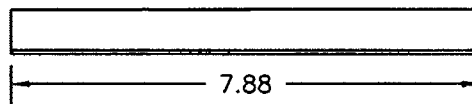
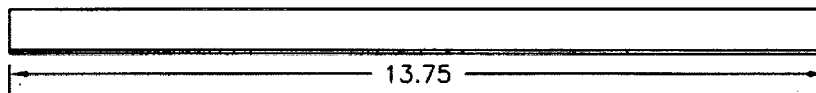
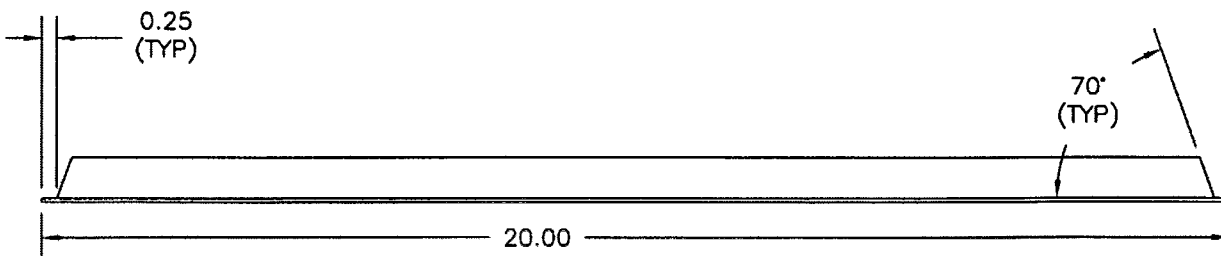
NOTE: Date & initial all entries

DART

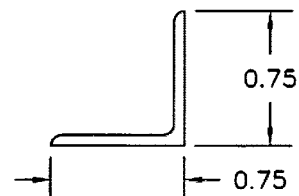
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CHECKED PH	APPROVED PH	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

RELEASED

05.03.31 PH

D3360-1
(SCALE 1:3)D3360-3
(SCALE 1:3)D3360-5
(SCALE 1:3)

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NO. 47916

**D3360-1/-3/-5 ANGLE**

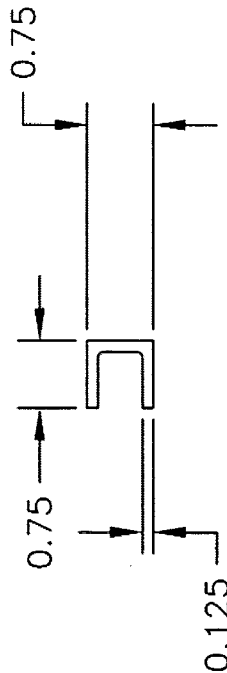
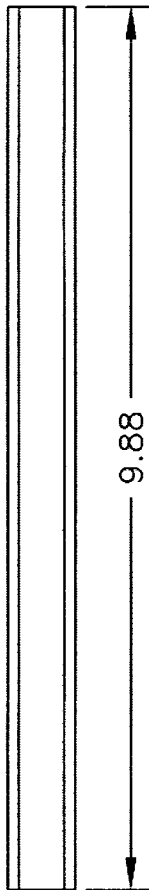
- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A
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DATE 04.11.29		TITLE CHANNEL	SCALE 1:2
A	04.11.29	NEW ISSUE	



SECTION A-A

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05.0331

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NO. 47914

D3361-1 CHANNEL

1) CUT LENGTH/SHAPE PER DIAGRAM

2) MATERIAL: 6063-T52 ALUMINUM

STOCK SIZE: 3/4" x 3/4" x 0.125" CHANNEL EXTRUSION

3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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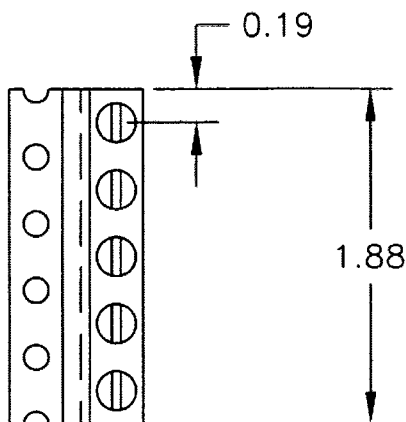
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DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

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05-03 31 [Signature]



D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

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HAMKESBURY, ONTARIO, CANADA

REV. C

SHEET 1 OF 3

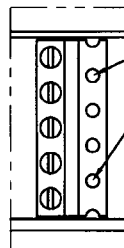
DESIGN	DRAWN BY	DRAWING NO.	TITLE	SCALE
P11	PH	D3363	CONSOLE ASSEMBLY	1:5
CHECKED	APPROVED			
DATE				
07.01.26				

A	04.11.29	NEW ISSUE
B	05.03.28	INCREASE WIDTH BY 0.125
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100") FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

DETAIL C

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

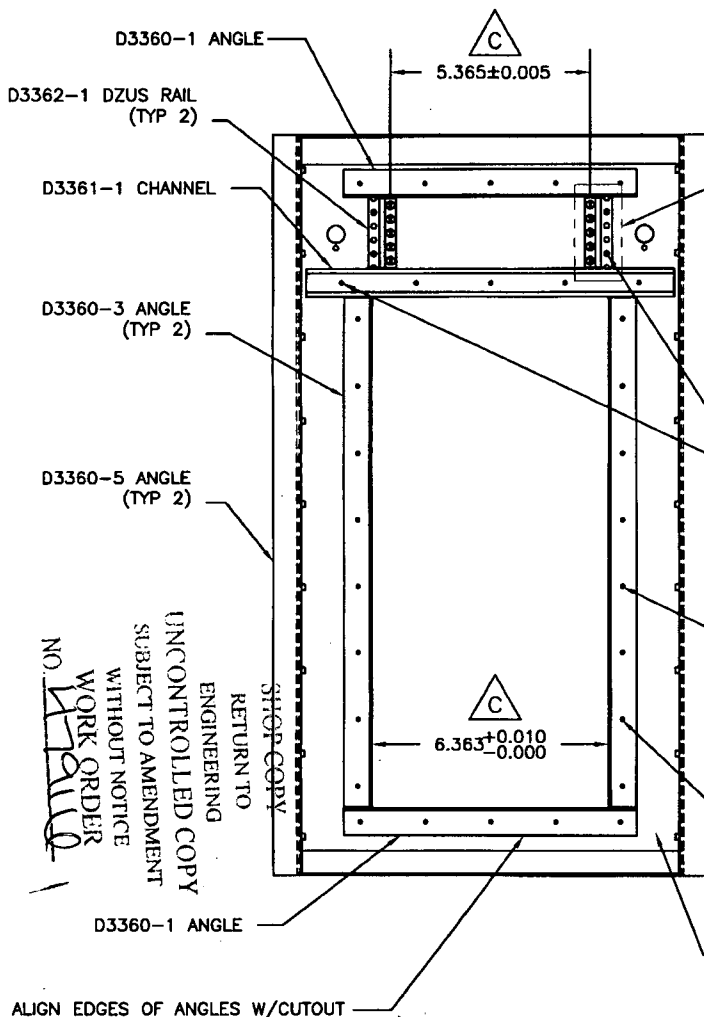
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



VIEW A-A FROM UNDER CONSOLE ASSEMBLY

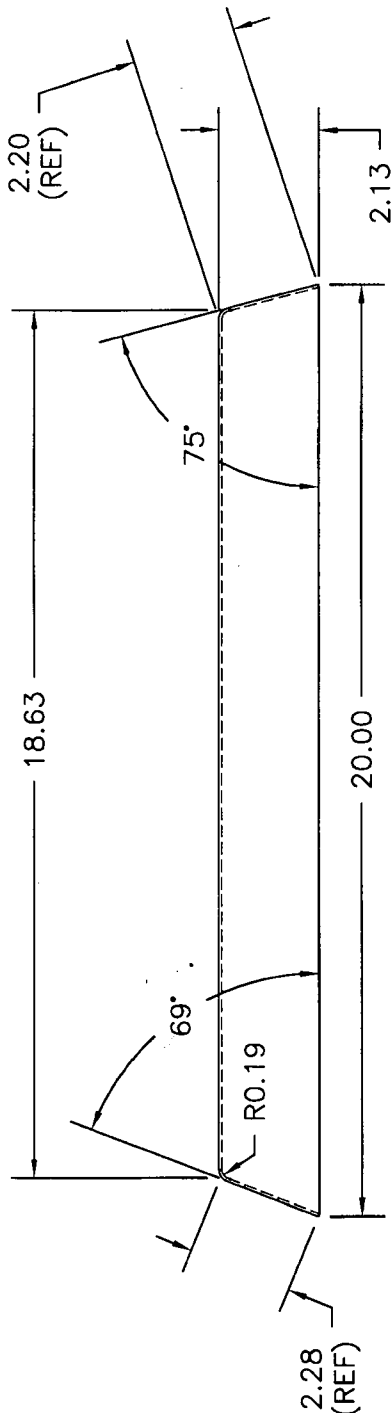
D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

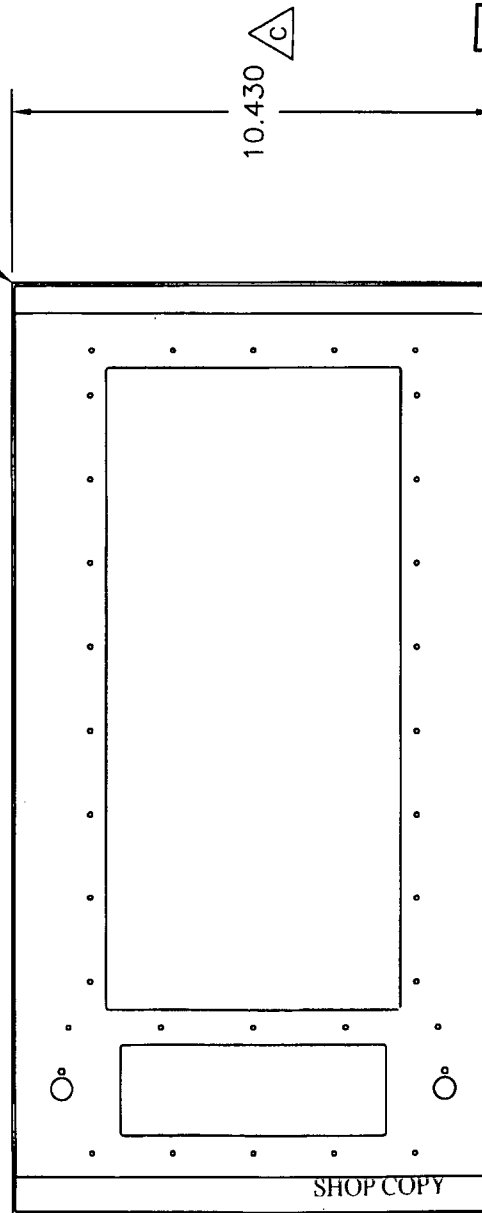
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DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



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07.06.04

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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D3363-1 CONSOLE

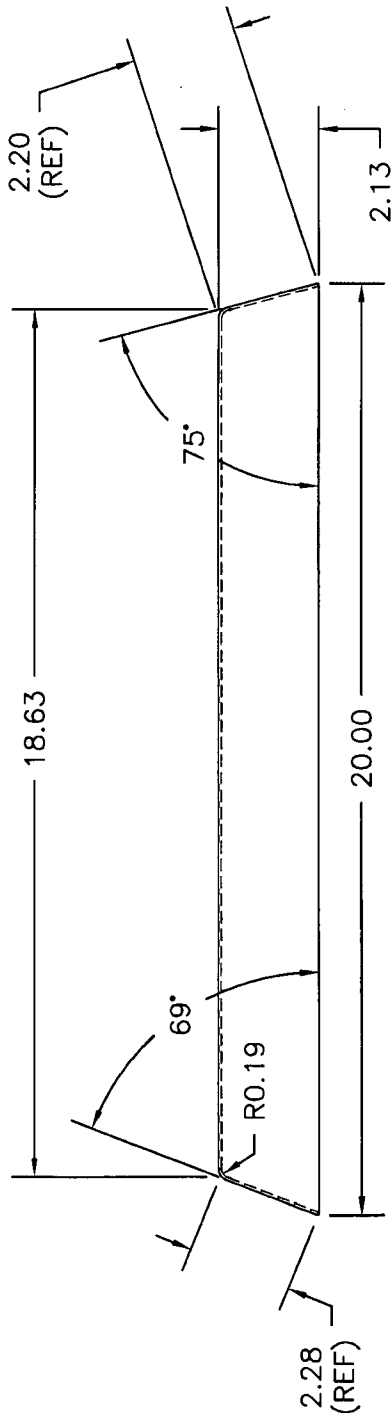
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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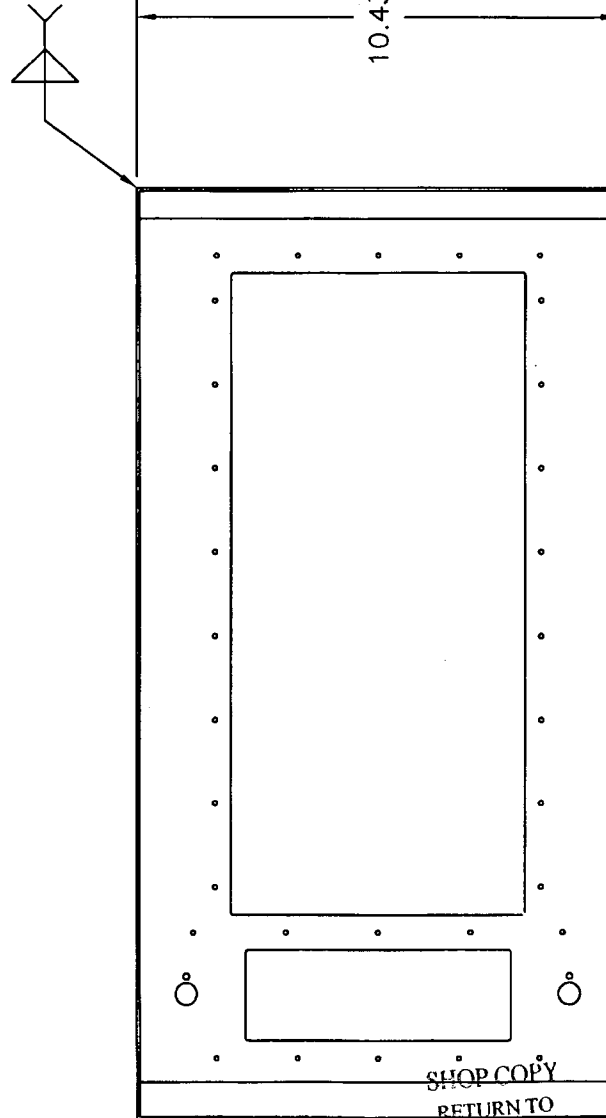
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *[Signature]*

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

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D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
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